

Work Order ID 84009

84009

May-01-12 10:40:43 AM

Page 1

Item ID: D4108-9

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fitting, Litter Door

Start Date: 01/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/01 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4108	12-05-02								
100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	cut to 3.750"								
110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA964								
	FOLIO REV: AA								
	DWG REV: B								
	DEBURR								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84009

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 01/05/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 15/05/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

OC

Memo

0.00

Quality Control

132

Chemical Conversion Coat per QSI005 4.1

0.00

132

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 84009

84009

Page 3

May-01-12 10:40:43 AM

Item ID: D4108-9

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Fitting, Litter Door

Stop

NS2

Start Date: 01/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

133

QC3- Inspect Part Finish

0.00

133

QC

Memo

0.00

Quality Control

12

12/6/85

140

Identify as per dwg & Stock Location: 910

0.00

140

Packaging

Memo

0.00

Packaging

12

12/6/85

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/6/11

MF
12-06-08

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:40:47 AM

Page 1

Work Order ID: 84009

84009

Parent Item: D4108-9

D4108-9

Parent Item Name: Fitting, Litter Door

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-10-12 VERIFIED BY:DD
Rev:B 10.12.03 as per dwg rev.B DD-verf:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			100	f	14.3483	0.3125	1.973684			

M6061T6B2 000X03 500

6061-T6 Bar 2.00 x 3.50

12660

3.75' **

12-05-14

Location

MAT009

112764

118182

118641

Loc Qty

14.3483

0.7284

11.4527

2.1672

Loc Code

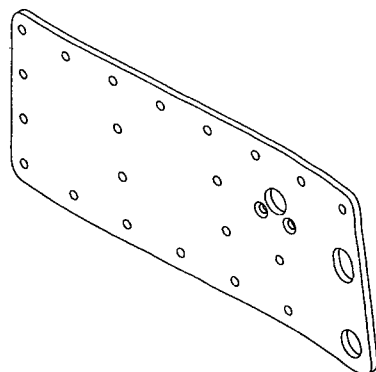
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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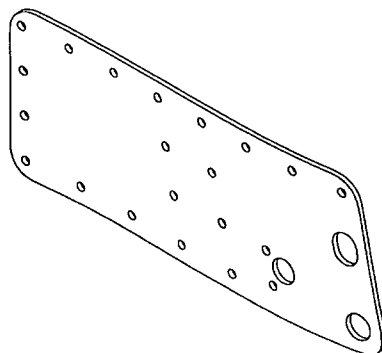
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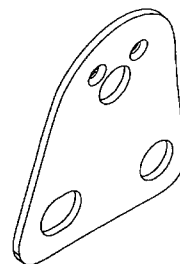
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D4108-1 LEFT PASS DOOR DOUBLER

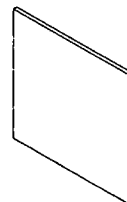


D4108-3 RIGHT PASS DOOR DOUBLER



D4108-5 SMALL RIGHT DOOR DOUBLER

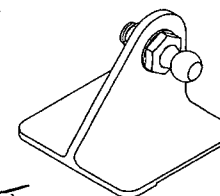
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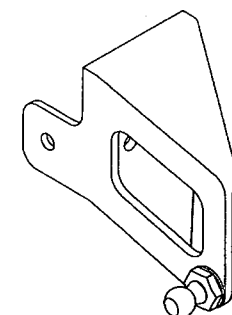
D4108-11 TEMPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84009 MJS

12/05/01



D4108-047 SILL BRACKET ASSEMBLY



D4108-049 LITTER DOOR FITTING ASSEMBLY

RELEASED
2010-11-30

B	D4108-5 (ZN C4-1 & B4-4) VIEWS UPDATED. D4108-7/-9 MTL CHANGED TO 6061-T6 AL. NOTES UPDATED (SHT 5,6)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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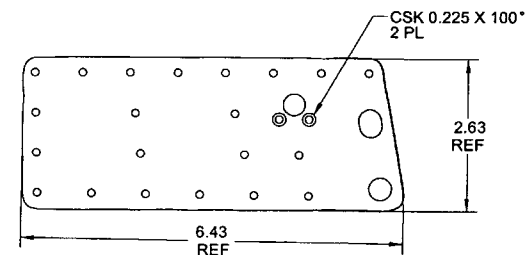
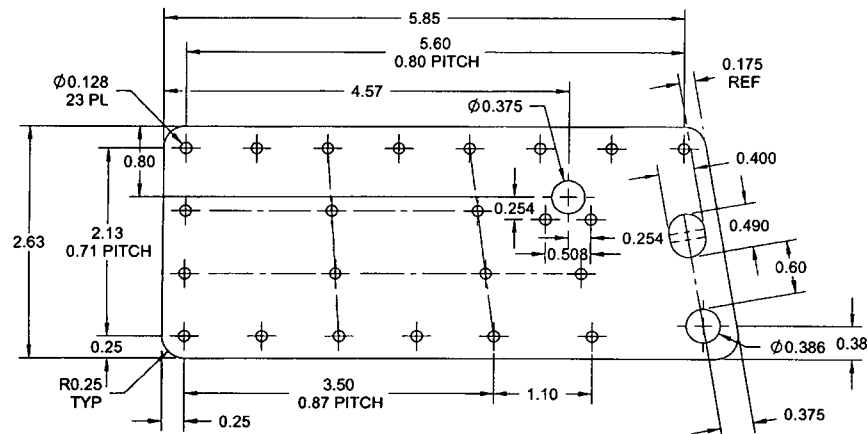
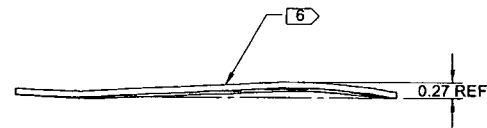
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D4108-1 LEFT PASS DOOR DOUBLER 8
(MAKE FROM D4108-1F)

D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-1 : MAKE FROM D4108-1F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -1: P/N D4108-1 & B/N PER QSI D44 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9648.

RELEASED
2010-11-30
wp

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MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

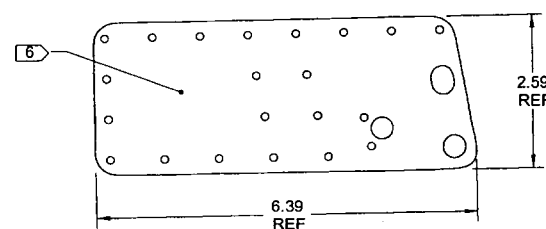
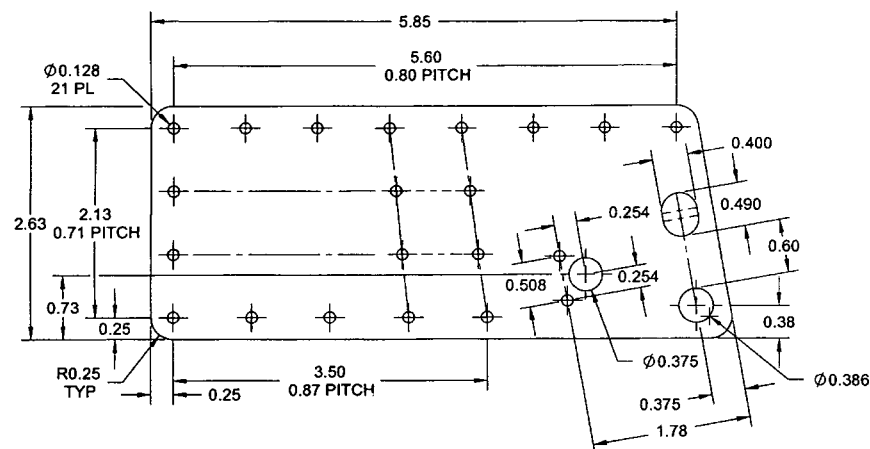
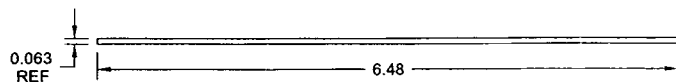
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84009



D4108-3 RIGHT PASS DOOR DOUBLER (MAKE FROM D4108-3F)

D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER

NOTES:

- 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-3: MAKE FROM D4108-3F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9649

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2010-11-30

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CHECKED	JPH	DRAWING NO. D4108	REV. B
MFG. APPR.			SHEET 3 OF 7
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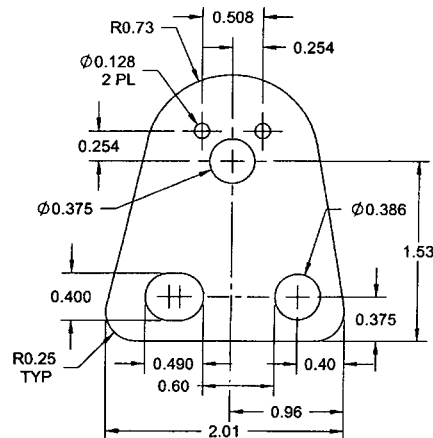
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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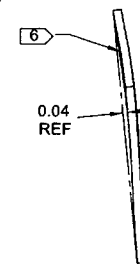
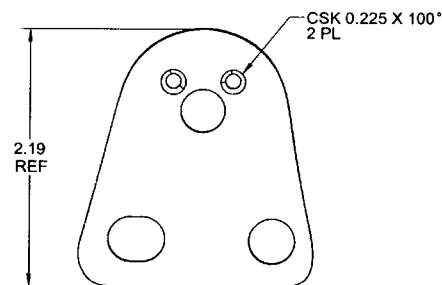
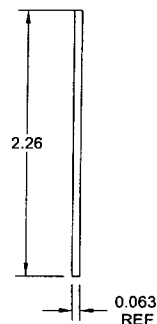
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER






D4108-5 SMALL RIGHT DOOR DOUBLER (MAKE FROM D4108-5F)

NOTES:

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-5: MAKE FROM D4108-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9649.

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2010-11-30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

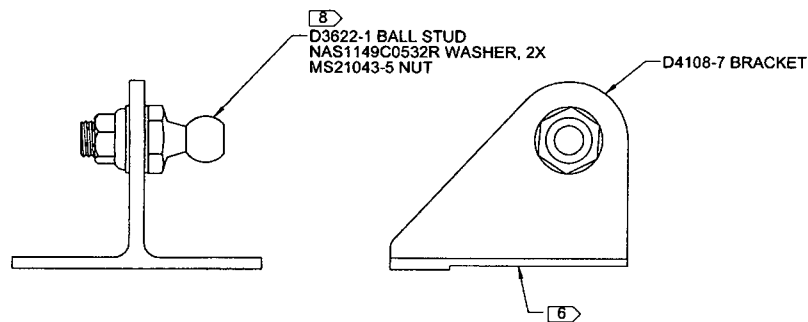
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

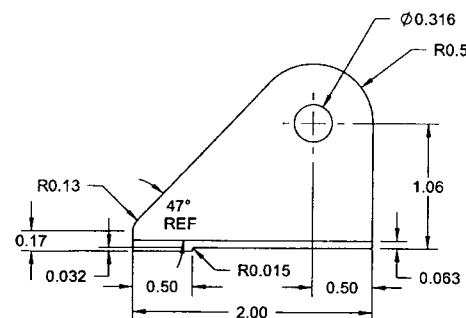
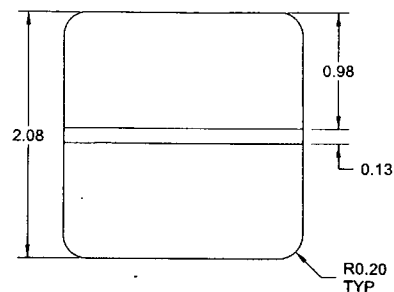
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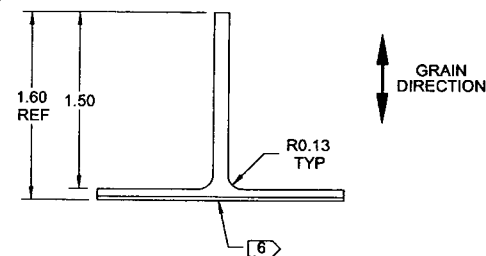
Qty	Part Number	Description
-047	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER






D4108-047 SILL BRACKET ASSEMBLY



D4108-7 BRACKET



- NOTES:**
- 1) MATERIAL -7: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
 - 7) WEIGHT -047: 0.10 lbs
 - 8) TORQUE TO 5-10 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 5 OF 7
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2010-11-30

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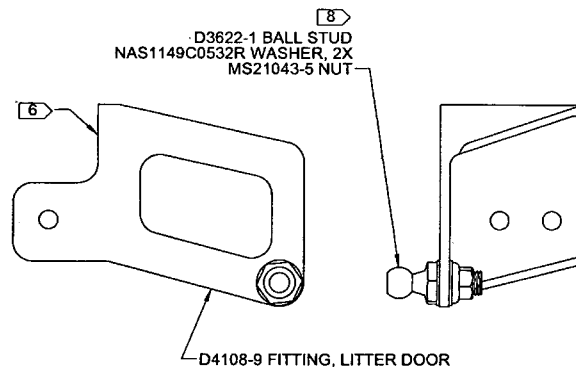
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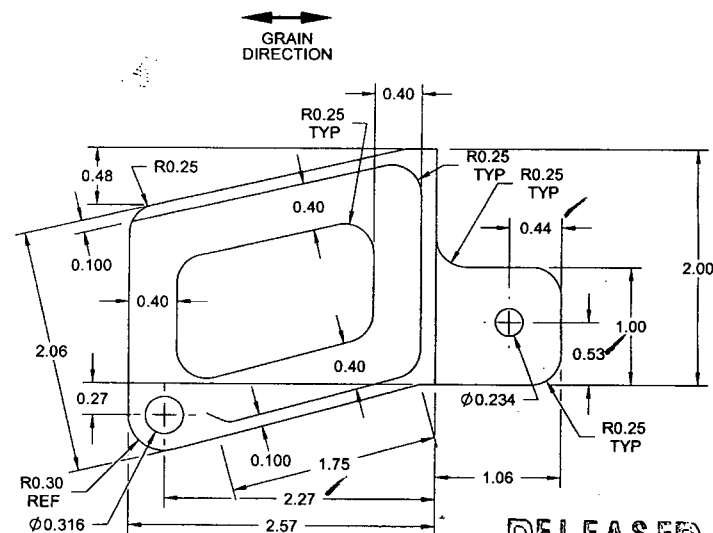
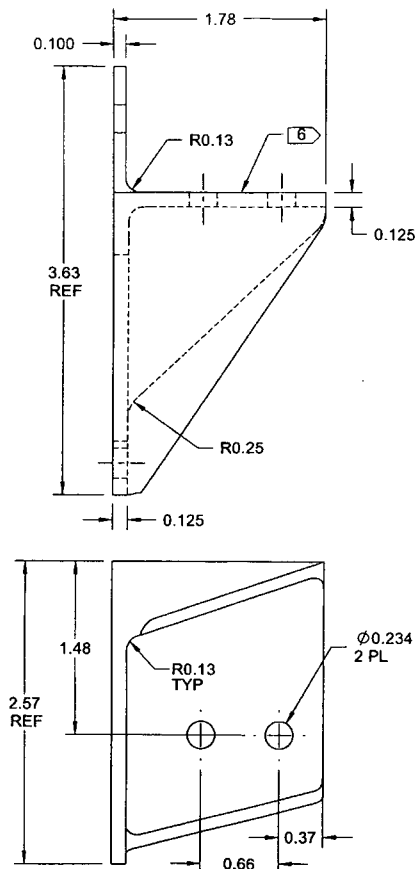
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty	Part Number	Description
1	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-049 LITTER DOOR FITTING ASSEMBLY



D4108-9 FITTING, LITTER DOOR

- NOTES:**
- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
 - 7) WEIGHT -049: 0.19 lbs
 - 8) TORQUE TO 15 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS & FITTINGS	NTS
DATE	10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-11-30

236/2
1-362
1-118
1-481
2-115

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

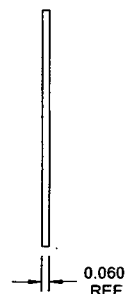
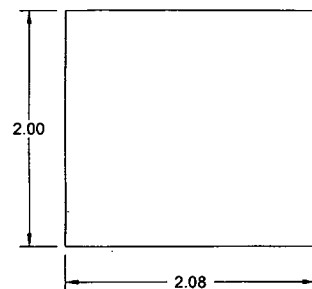
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84009



D4108-11 TEMPLATE

NOTES:

- 1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-11 PER QSI 044 6.1
- 7) WEIGHT: N/A

RELEASED
2010-11-30
N/A

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4108	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 7 OF 7	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 84009
Description: Fitting, litter door		Part Number: D4108-9
Inspection Dwg: D4108	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.100	$\pm .010$.097	✓		Vern	SL-10
3.63	$\pm .030$	3.630	✓		-	
.125	$\pm .010$.121	✓		-	
.125	$\pm .010$.124	✓		-	
1.13	$\pm .030$	1.125	✓		R-G	
1.78	$\pm .030$	1.779	✓		-	
1.48	$\pm .030$	1.479	✓		-	
2.57	$\pm .030$	2.570	✓		-	
1.13	$\pm .030$.125	✓		R-G	
.66	$\pm .030$.66	✓		-	
.37	$\pm .030$.368	✓		-	
Ø.234	$\begin{matrix} +.004 \\ -.001 \end{matrix}$.238	✓		-	
.48	$\pm .03$.485	✓		H-G	
.100	±.010 $\pm .010$.097	✓		Vern	SL-10
2.06	$\pm .030$	2.054	✓		-	
.40	$\pm .030$.400	✓		-	
.27	$\pm .030$.268	✓		H-G	
Ø.316	$\begin{matrix} +.005 \\ -.001 \end{matrix}$.317	✓		Vern	SL-10
2.27	$\pm .030$	2.27	✓		H-G	
.100	$\pm .030$.097	✓		Vern	SL-10
.40	$\pm .030$.403	✓		-	
1.06	$\pm .030$	1.06	✓		H-G	
Ø.234	$\begin{matrix} +.004 \\ -.001 \end{matrix}$.238	✓		Vern	SL-10

Measured by: SL / JRP
Date: 12-06-06

Audited by: J.A
Date: 12/06/07

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

